



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

010960

D4634-145

Job Sheet 197084



Part No: D4634-145

Job Qty: 1 pcs

Part Name: Aft, Center Ceiling Replacement Panel Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 6/28/19

Job Tracking No:

Due Date: 8/2/19

Created By: Kimberley Guerin

Type: SOLD

Description:

Note: DWG D4634 REV.H SHEET 9 IPP Rev. A 12/08/09 New Issue DL IPP Rev B 12/11/08 Document release DL
VERIFIED BY:JLM IPP Rev C 13/07/09 Dwg Update DL ver: DD IPP Rev D Dwg Update 13/12/23 DL IPP
REV E Dwg update 14/01/09 DL IPP Rev F Dwg. update 14/02/03 DL IPP Rev G Dwg. Update 15/01/27 DL

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Small Fab - 1	1 pcs	8/2/19		0.00	1.47	Small Fab - 1		SMB 10/7/18
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
120	QC 5	1 pcs	8/2/19		0.00	0.00	QC 5 - 10		DAS JUL 19 2019 40 9-89
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
130	Packaging 3-1 - Stock - B4B	1 pcs	8/2/19		0.00	0.00	Packaging 3 - 1 - B4B		DAS JUL 19 2019 40 9-89
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		
							Packaging 3 - 6 - B4B		

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				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
140	QC 21 - SA	1 pcs	8/2/19	0.00 0.00	QC 21 - SA - 21
					QC 21 - SA - 70
					QC 21 - SA - 53

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Part Op 110 - Small Fab (Small Fab) Assemble as per Dwg D4634-145 Bond foam core to inside of panel 3M Scotch Weld 1300
 Descriptions: Batch: m138775 1- Scuff bonding surface to eliminate in-perfections and increase bonding and clean with wash& wipe 2- Locate and glue down Channel Assy, angles, brackets, and mounting pads using 3M Plastic welder II. (see note 8) Batch # S159491 Expiry Date 02/01/2020 3- Apply labels as per Dwg. and seal with 3M 3950 edge sealer (see note 9) Batch: m138961
 120 - QC5 (QC5- Inspect part completeness to step on W/O) QC5- Inspect part completeness to step on W/O
 130 - Packaging3 (Identify as per dwg & Stock Location: _____) Identify as per dwg & Stock Location: _____
 140 - QC21 (QC21- Final Inspection - Work Order Release) QC21- Final Inspection - Work Order Release

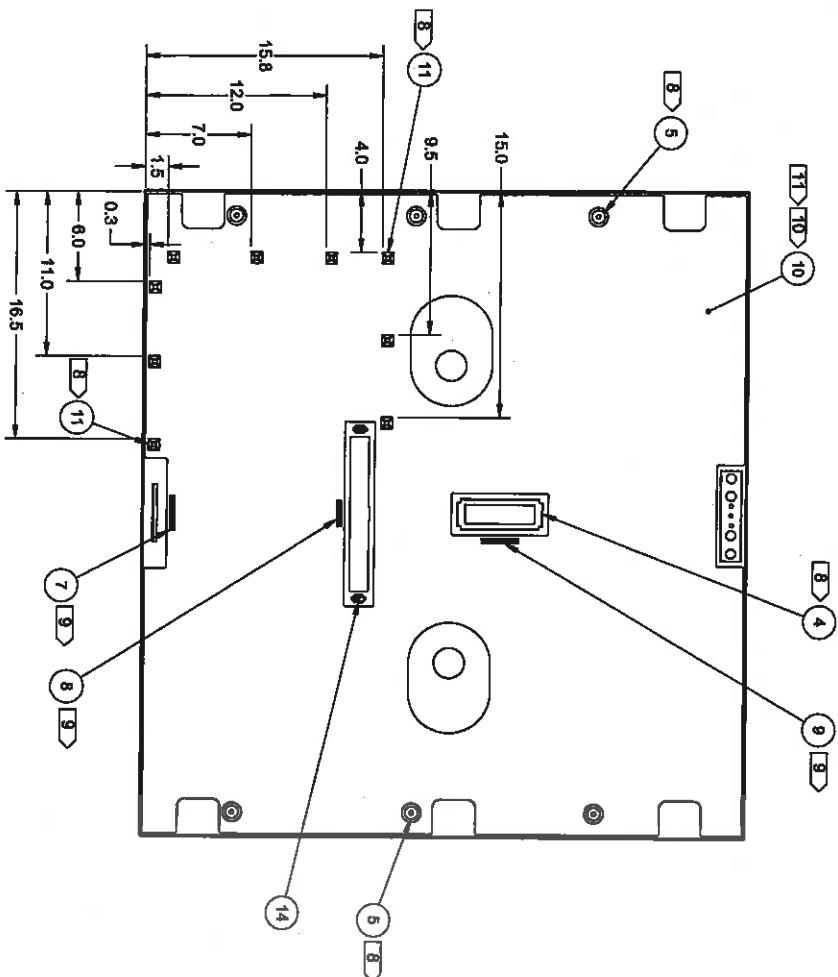
Job BOM

Part / Item	Component Name	Quantity	Operation	Container
CCR264SS-3-03	Cherry Rivet	4 Ea (4 ea)	110-Small Fab - 1	S180315
D4634-5	Aft, Center Ceiling Panel	1 pcs (1 ea)	110-Small Fab - 1	S131090
D4636-5	Bracket	1 pcs (1 ea)	110-Small Fab - 1	S122038
D4647-1	Doubler	1 pcs (1 ea)	110-Small Fab - 1	S113182
D4664-5	Spacer	6 pcs (6 ea)	110-Small Fab - 1	S132128
D4712-1	Bracket	1 pcs (1 ea)	110-Small Fab - 1	S04996
D4732-17	Label	1 pcs (1 ea)	110-Small Fab - 1	S04121
D4732-23	Label	1 pcs (1 ea)	110-Small Fab - 1	S13572
D4732-27	Label	1 pcs (1 ea)	110-Small Fab - 1	S18570
D5021-5	Foam, Center Panel, Aft	1 pcs (1 ea)	110-Small Fab - 1	S123642
MPNY-750S-9-C	Mounting Pad	9 pcs (9 ea)	110-Small Fab - 1	fm1304237
MS20426AD4-6	Rivet	2 Ea (2 ea)	110-Small Fab - 1	S095088
MS21059L08	Nut	2 Ea (2 ea)	110-Small Fab - 1	S140391

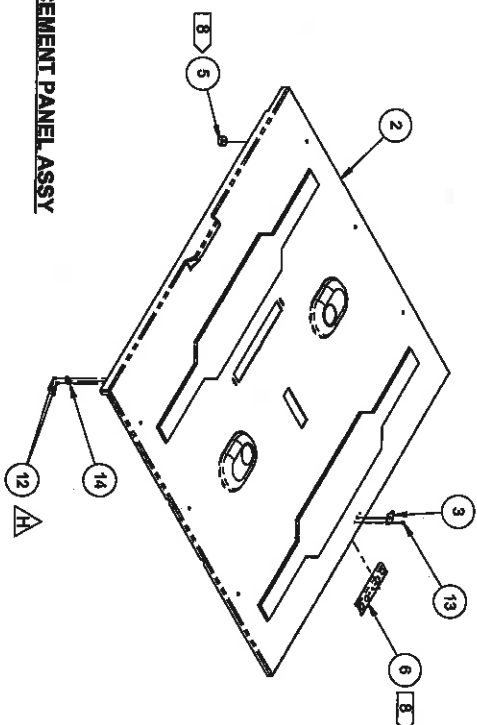
Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
110-Small Fab - 1	CCR264SS-3-03	4	408	0
	D4634-5	1	3	0
	D4636-5	1	60	0
	D4647-1	1	5	0
	D4664-5	6	25	0
	D4712-1	1	4	0
	D4732-17	1	15	0
	D4732-23	1	20	0
	D4732-27	1	2	0
	D5021-5	1	2	0
	MPNY-750S-9-C	9	127	0
	MS20426AD4-6	2	1,110	0
	MS21059L08	2	164	0
Part Specifications				
Specifications could not be found.				

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ITEM	QTY	PIN	DESCRIPTION
1	X	D4634-145	AFT. CENTER CEILING REPLACEMENT PANEL ASSY
2	1	D4634-5	AFT. CENTER CEILING PANEL
3	1	D4636-5	BRACKET
4	1	D4647-1	DOUBLER
5	6	D4694-5	SPACER
6	1	D4712-1	BRACKET
7	1	D4732-17	LABEL
8	1	D4732-23	LABEL
9	1	D4732-27	LABEL
10	1	D5021-5	FOAM, CENTER PANEL, AFT
11	9	MPNY-7505-9-C	ACOUNTING PAD
12	4	CCR264SS-3-(09)	RIVET, BLIND, CSK
13	2	MS20428AD4-(6)	RIVET, SOLID, CSK
14	2	MS21058LDB	NUT PLATE



D4634-145 AFT. CENTER CEILING REPLACEMENT PANEL ASSY



- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER PART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: N/A
 - 8) APPLY A BEAD (0.20 TO 0.30 WIDE) OF DEVCON PLASTIC WELDER II (0.25 INSIDE OF BOTH EDGES OF PART) TO BOND D4647-1 & MPNY-7505-9C. WAIT FOR 2 TO 4 HOURS FOR FUNCTIONAL CURE.
 - 9) LOCATE LABELS AS SHOWN. SEAL LABELS USING 3980 EDGE SEALER OVER LABEL. TOP SURFACE
 - 10) APPLY AN EVEN COAT OF 3M SCOTCH WELD 1300L CONTACT ADHESIVE TO BOND D5021-5 FOAM CORE TO INSIDE OF PANEL
 - 11) CENTER D5021-5 FOAM ON D4634-5

RELEASED

2019 APR 22

APPROVED

DESIGN	RF	DATE	17.05.16
DRAWN	VS		
CHECKED	RF		
MG, APPR	DD		
APPROVED	ML		
DE APPR	DS		
TITLE			
CENTER CEILING PANELS			
SCALE			
NTS			

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